

# Work Order ID 63296



Page 1

Wednesday, October 27, 2010 10:49:36 AM

Item ID: D212-725-1-017A

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten initials*

Date:

*10/10/27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	B								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*186-10-28*

*(2)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*186-10-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

*Slows*

*2*

*see Attached Email for missing holes.*

*2*

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

*2*

*BF 10/10/28*

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

*=> JH*

*10/10/28*

*2*

*0*

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63296**

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Wednesday, October 27, 2010 10:49:36 AM

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Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 10/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: 383

0.00



Packaging

Memo

0.00

Packaging

10/10/29 e

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 MF  
10-10-29

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, October 27, 2010 10:49:44 AM

Page 1

Work Order ID: 63296



Parent Item: D212-725-1-017A



Parent Item Name: Doubler

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

103.8847

0.085

0.178947



1310-10-28

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

103.8847

111381

11.89

113189

0.3947

114968

91.6

114968

2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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D212-725-1-67A

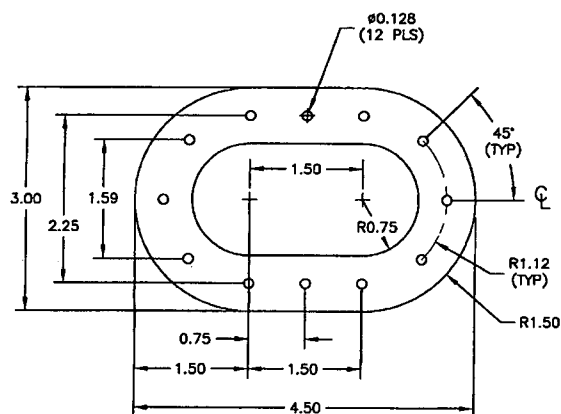
X	First Article	X	Prototype
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Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>10-10-28</u>	Date: <u>10/10/28</u>	Date:

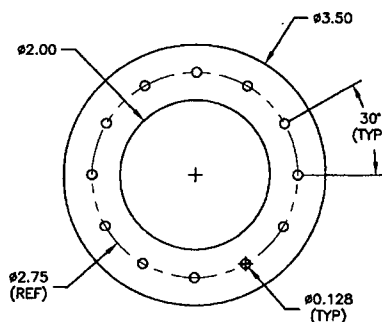
H:\FORMS\Quality Assurance\approved QA\FAI revD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43294

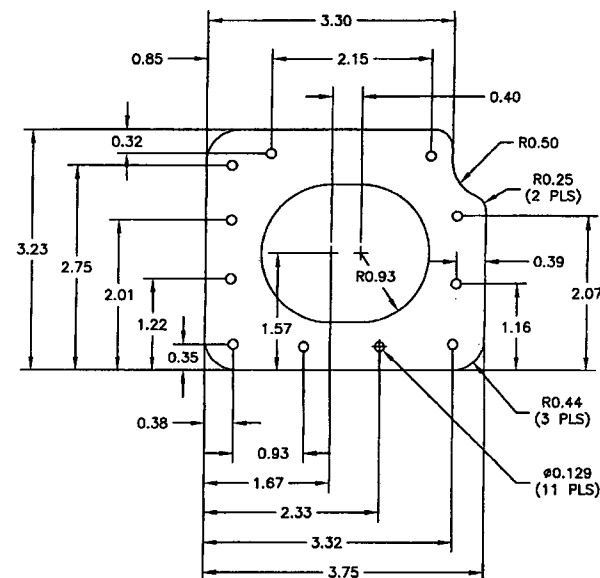
*PS 10-10-27*



**D212-725-1-005 DOUBLER**



**D212-725-1-017A DOUBLER**



**D212-725-1-017B DOUBLER**

**D212-725-1-005/-017A/-017B NOTES:**

- 1) MATERIAL: 2024-T3 (00-A-250/4) 0.050 ALUMINUM SHEET (REF. DART SPEC. M2024T3S0.050)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASED  
2009-10-28

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN DS	DRAWN BY RF	<b>DART</b> DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED DS	APPROVED [Signature]	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 3 OF 44 SCALE NTS

W/O:		WORK ORDER CHANGES					
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**L Lacelle**

**From:** Robert Fuentes [rfuentes@dartaero.com]  
**Sent:** October 27, 2010 1:03 PM  
**To:** 'L Lacelle'  
**Cc:** 'H. Siemens'; 'David Shepherd'  
**Subject:** RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Wednesday, October 27, 2010 9:47 AM  
**To:** 'Robert Fuentes'  
**Cc:** 'H. Siemens'; 'David Shepherd'  
**Subject:** FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?

Please next time let someone know that the dwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

**From:** David Duval [mailto:dduval@dartaero.com]  
**Sent:** October 27, 2010 11:43 AM  
**To:** Linda Lacelle  
**Subject:**

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

**David Duval**

*Production Engineering Coordinator*



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 Hawkesbury Ontario  
 Canada K6A 1K7  
 Tel: (613) 632-5200

dduval@dartaero.com



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10/27/10